

Work Order ID 75900

75900

Page 1

November-02-11 10:08:19 AM

Item ID: D412-742-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Float Skidtube Installation

Stop

NS2

Start Date: 01/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/11/02 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


Draw Nbr	Revision Nbr
DSI 9517	B
IIN D412-742	D

100

100

DC

Document Control

DOCUMENT CONTROL 

0.00

Memo

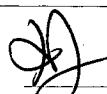
0.00

Photocopy bluefile and create labels per PPP D412-742-013

CHG006

CHG007

CP 11.11.06

 GERM 12-1-3

110

110

Packaging

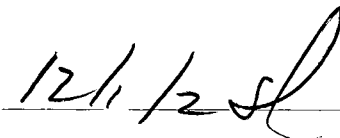
Packaging

Pick Kit

0.00

Memo

0.00

 12/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75900***75900***

Page 2

November-02-11 10:08:20 AM

Item ID: D412-742-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Float Skidtube Installation

Start Date: 01/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

w 12 01 05 (1)

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-013

Location: _____

Rev Draft

Sp 12-01-05.

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/1/9 J

UMF
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:08:23 AM

Page 1

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP RevF: add AN4C7A DD 10.01.13 verified by: EC IPP Rev: G 11.11.01 as per DSI9517 REV.B DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C53A *AN4C53A* Bolt		Purchased	No			110	Each	21.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST361				21					
				115723				10					
				119447				11					
AN4C7A *AN4C7A* Bolt		Purchased	No			110	Each	315.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST356				315					
				109147				315					
D3403-5 *D3403-5* Bushing		Manufactured	No			110	Each	108.0000	8	8			
				<u>Location</u>				<u>Loc Qty</u>					
				FG052				100					
				74761				100					
				ST361				8					
				66530				8					

10

M119688

4

8
B7503 12/1/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

November-02-11 10:08:23 AM

Page 2

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D412-742-043

Manufactured No

110 Each

0.0000

1 1

D412-742-043

Replacement Float Skidtube

D2571

Manufactured No

110 Each

3.0000

1 1

D2571

Saddle, Fwd Out 205

**

**

B75911

B774460

Location

Loc Qty

Loc Code

ST433

3

72969

3

D2572

Manufactured No

110 Each

2.0000

1 1

D2572

Saddle, Fwd In 205

**

B772465

Location

Loc Qty

Loc Code

ST433

2

71107

2

D2573

Manufactured No

110 Each

0.0000

1 1

D2573

Saddle, Aft Out 205

D2574

Manufactured No

110 Each

0.0000

1 1

D2574

Saddle, Aft In 205

D2876

Manufactured No

110 Each

23.0000

2 2

D2876

Saddle Spacer

**

**

**

B77287

B77286

B76949

Location

Loc Qty

Loc Code

ST025

23

72136

23

November-02-11 10:08:23 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:08:23 AM

Page 3

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2877

Manufactured No

110

Each

87.0000

2

D2877

Saddle Spacer

**

Location

Loc Qty

Loc Code

ST025

87

72135

21

73309

66

Manufactured No

110

Each

44.0000

8

D3403-1

D3403-1

Bushing

**

Location

Loc Qty

Loc Code

ST052

44

70696

15

75672

29

Manufactured No

110

Each

126.0000

4

D2747

D2747

Set Screw

**

Location

Loc Qty

Loc Code

ST021

126

71163

26

73495

100

Manufactured No

110

Each

84.0000

2

D3533-1

D3533-1

Set Screw

**

Location

Loc Qty

Loc Code

ST065

84

73310

84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:08:23 AM

Page 4

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

330.0000

16

AN4C6A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

326

116704

15

118451

11

118983

100

119328

200

AN4C52A

Purchased

No

110

Each

61.0000

4

AN4C52A

BOLT

**

Location

Loc Qty

Loc Code

ST361

61

117163

8

117688

7

118451

46

AN6C12A

Purchased

No

110

Each

16.0000

8

AN6C12A

BOLT

**

Location

Loc Qty

Loc Code

ST341

16

118422

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:08:24 AM

Page 5

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-3 Manufactured No 110 Each 691.0000 32

D3672-3

Phenolic Washer

**

32

Location

Loc Qty

Loc Code

ST074

691

64176

180

72230

11

73487

500

AN960C416L Purchased No 110 Each 0.0000 32

*AN960C416L *

WASHER

**

32

D3672-9 Manufactured No 110 Each 232.0000 8

D3672-9

Phenolic Washer

**

8

Location

Loc Qty

Loc Code

ST074

232

35523

232

NAS1149C0632R Purchased No 110 Each 88.0000 8

NAS1149C0632R

WASHER

**

8

Location

Loc Qty

Loc Code

ST297

88

118006

88

D3672-11 Manufactured No 110 Each 99.0000 8

D3672-11

Phenolic Washer

**

8

Location

Loc Qty

Loc Code

ST074

99

58046

99

November-02-11 10:08:24 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:08:24 AM

Page 6

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,105.000

29

29

MS21043-4

Nut

**

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1065

117793

65

118686

500

119309

500

D3403-3

Manufactured

No

110

Each

13.0000

8

8

D3403-3

Bushing

**

Location

Loc Qty

Loc Code

ST

3

69509

3

ST052

10

71852

10

D3405-041

Manufactured

No

110

Each

12.0000

1

1

D3405-041

Lug Assembly

**

Location

Loc Qty

Loc Code

ST474

12

62227

2

73338

10

November-02-11 10:08:24 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:08:24 AM

Page 7

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110 Each

6.0000

1 1

D3405-043

Lug Assembly

**

3762218

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST478

4

73339

4

AN4C47A

Purchased No

110 Each

57.0000

4 4

AN4C47A

Bolt

**

Location

Loc Qty

Loc Code

ST361

57

117163

7

118451

50

D3407-041

Manufactured No

110 Each

25.0000

1 1

D3407-041

Tow Ring

**

Location

Loc Qty

Loc Code

ST463

25

75029

25

D3417-3

Manufactured No

110 Each

60.0000

2 2

D3417-3

Washer

**

Location

Loc Qty

Loc Code

FG

9

33519

9

ST053

51

51648

4

53182

23

66847

24

November-02-11 10:08:24 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-02-11 10:08:24 AM

Page 8

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110 Each

96.0000 1 1

D3456-1

Washer

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

89

66848

3

71165

2

73493

84

AN3C37A

Purchased No

110 Each

132.0000 1 1

AN3C37A

BOLT

**

Location

Loc Qty

Loc Code

ST354

132

116874

11

117010

2

118518

44

118709

50

119324

25

AN3C40A

Purchased No

110 Each

73.0000 1 1

AN3C40A

BOLT

**

Location

Loc Qty

Loc Code

ST354

73

112454

23

114442

50

November-02-11 10:08:24 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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November-02-11 10:08:24 AM

Page 9

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

98.0000

1

AN3C41A

BOLT

**

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

94

119035

44

119324

50

AN3C42A

Purchased

No

110

Each

38.0000

1

AN3C42A

BOLT

**

Location

Loc Qty

Loc Code

ST354

38

106176

1

117763

17

118131

20

AN3C43A

Purchased

No

110

Each

38.0000

4

AN3C43A

BOLT

**

Location

Loc Qty

Loc Code

ST354

38

114455

13

118387

25

AN3C46A

Purchased

No

110

Each

47.0000

5

AN3C46A

BOLT

**

Location

Loc Qty

Loc Code

ST355

47

118758

47

W/O: _____		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: _____		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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November-02-11 10:08:24 AM

Page 10

Work Order ID: 75900

75900

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

110 Each 0.0000 26 26

*AN960C10I *

**

washer

MS21043-3 Purchased No

110 Each 727.0000 13 13

MS21043-3

**

Nut

Location

Loc Qty

Loc Code

FG	72	
103691	72	
ST301	655	
118077	1	
118614	477	
118686	177	

M1197308
M119901 12/1/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37
REF. FAA STC: SR01583SE
REF. EASA STC: EASA.IM.R.S.01126

PURPOSE:

The purpose of this service instruction is to introduce an alternate wearplate installation for the D412-742-011/-013 Skidtube Installations. The new DSI-9517-011 Wearplate Kit consists of new wearplates destined to replace existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets. The components in the DSI-9517-011 Wearplate Kit are as defined in the parts list on sheet 4 of this service instruction.

INSTALLATION PROCEDURE:

Replace D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets with D4095-041/-043 Wearplates Assemblies as follows:

1. Remove existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets per Item 32.6.1 of ICA-D412-742. It might be necessary to loosen the aft end of D3564-5 Wearshoe and D3566-5 Gasket.
2. Remove qty.(4) AN4C52A Bolts, D3403-1 Bushings, and qty.(8) D3672-11 Washers as indicated in Figures 1 and 2 of this service instruction.
3. Inspect the skidtube and saddles per Chapter 5 of ICA-D412-742.
4. Seal existing inserts located on both sides of the skidtube in area shown in Figures 1 and 2 of this service instruction using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant.
5. Locate the DSI-9517-011 Wearplate Kit as shown in Figure 1 and 2 of this service instruction.
6. Transfer drill qty.(2) Ø0.438 hole from the skidtube/saddle to the D4095-041/-043 Wearplates Assemblies. Deburr. Touch up finish per Item 5.2.14 of ICA-D412-742 as required.
7. Install the DSI-9517-011 Wearplate Kit using the same AN3C hardware as shown in ICA-D412-742. Torque to 15-25 in-lbs (1.7-2.8 N-m).
8. Install D3403-5 Bushings and AN4C53A Bolts in lieu of D3403-1 Bushings and AN4C52A Bolts removed at step 2 above. Ensure that the nuts on the AN4C Bolts are on the inboard side of the skidtube. Torque to 50-70 in-lbs (5.7-7.9 N-m).
9. Amend weight and balance per the Weight and Balance Table below.

WEIGHT AND BALANCE:

Use the following weight and balance information for DART D412-742-011/-013 skidtube and saddle installations equipped with DSI-9517-011 Wearplate Kit.

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D412-742-011 Float Skidtube Installation with DSI-9517-011 Kit Installed	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg
D412-742-013 Float Skidtube Installation with DSI-9517-011 Kit Installed	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg

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NO. 75900

M.C.J
11/11/02

B	ITEM 21B AND 22B REMOVED FROM PARTS LIST	XDF	11.10.11
A	NEW ISSUE	MB	10.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>J</u>	DART AEROSPACE USA, INC KENT, WA	
DRAWN	XDF		
CHECKED	<u>J</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 1 OF 6
APPROVED	<u>140</u>	TITLE	SCALE
DE APPR.	<u>140</u>	ALTERNATE WEARPLATE KIT	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

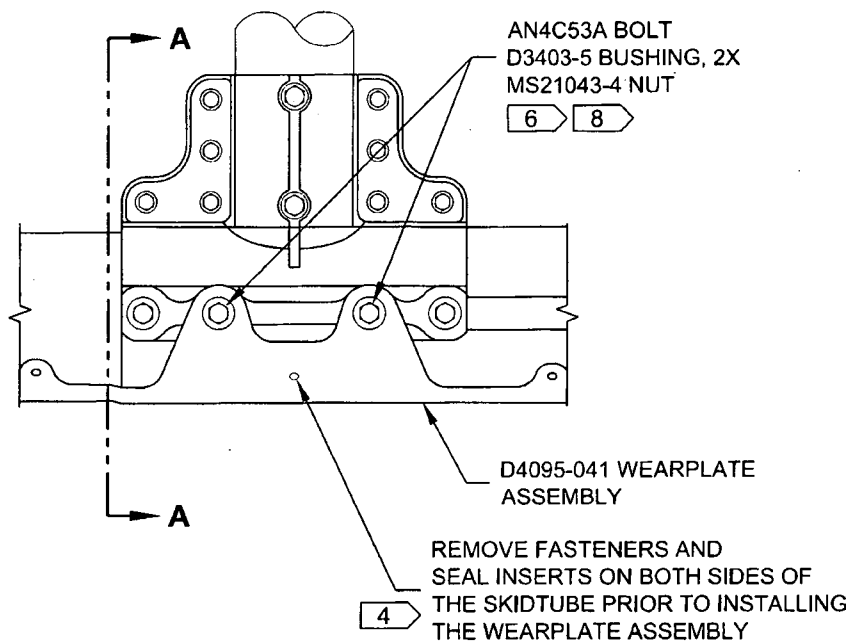
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

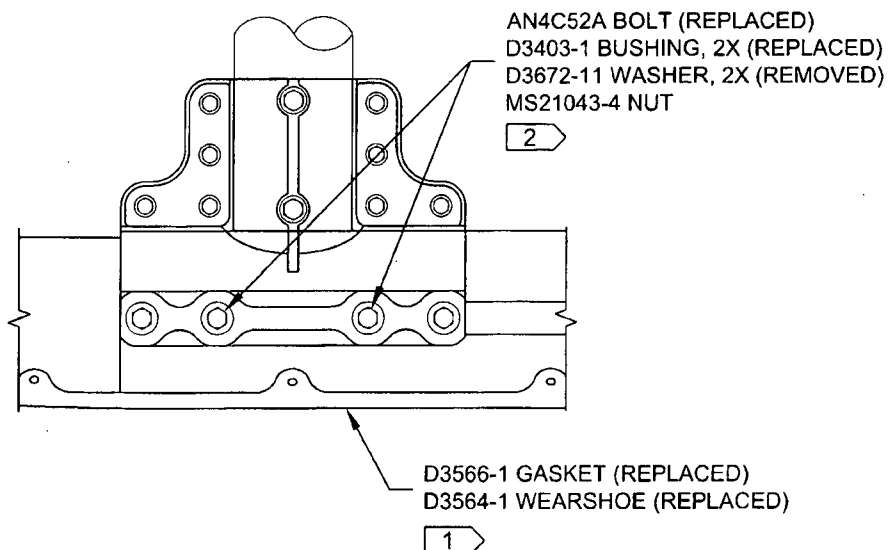
NOTE: Date & initial all entries

75900

IS:



WAS:



**FIGURE 1: CHANGE AT FORWARD SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

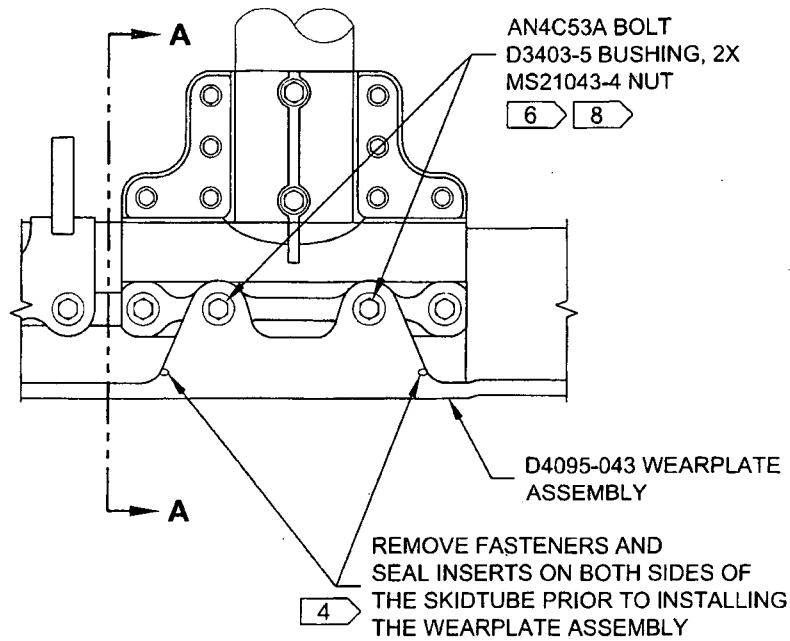
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

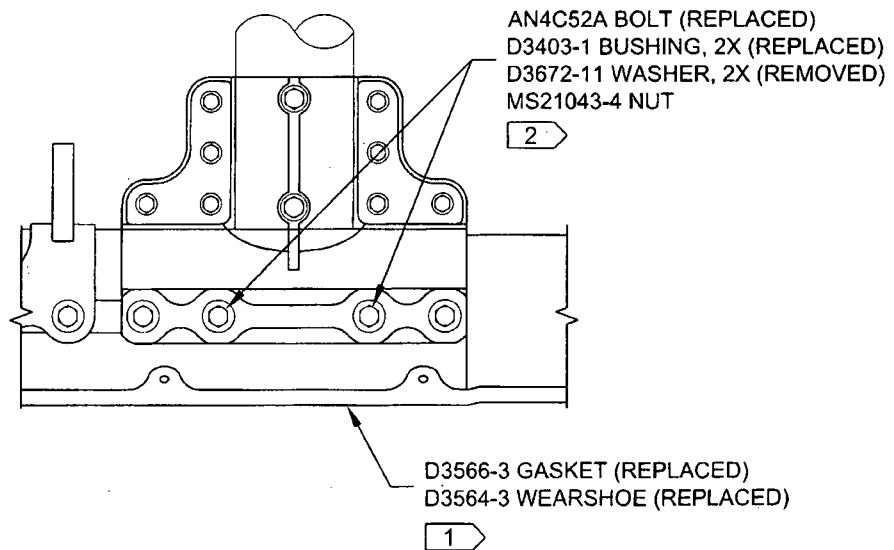
NOTE: Date & initial all entries

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IS:



WAS:



**FIGURE 2: CHANGE AT AFT SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 3 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

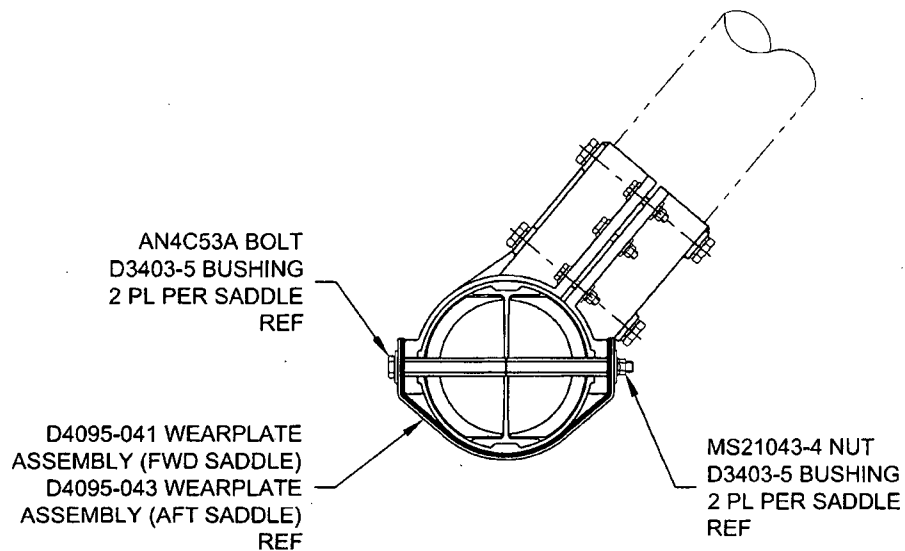
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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**SECTION A-A****DSI-9517-011 PARTS LIST:**

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9517-011	WEARPLATE KIT
8	D3403-5	BUSHING
1	D4095-041	WEARPLATE ASSEMBLY
1	D4095-043	WEARPLATE ASSEMBLY
4	AN4C53A	BOLT

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 4 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

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THE PARTS LISTS IN SECTION 32.15 OF ICA-D412-742 (PAGES 53 AND 55) AND SECTION 5.1 OF IIN-D412-742 (PAGES 16 AND 17) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.15 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)

5.1 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -011	QTY -041	QTY -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

3		10		AN3C6A	BOLT (REMOVED QTY.2)
4		4		AN3C7A	BOLT (REMOVED QTY.4)
5		38		AN960C10L	WASHER (REMOVED QTY.6)
21A		1		D4095-041	WEARPLATE ASSEMBLY
22A		1		D4095-043	WEARPLATE ASSEMBLY
46	8			D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8			D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4			AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4			AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8			D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12		AN3C6A	BOLT
4		8		AN3C7A	BOLT
5		44		AN960C10L	WASHER
21A		1		D3564-1	WEARPLATE
21B		1		D3564-3	WEARPLATE
22A		1		D3566-1	GASKET
22B		1		D3566-3	GASKET
46	16			D3403-1	BUSHING
49	8			AN4C52A	BOLT
53	16			D3672-11	WASHER

DESIGN	J	DART AEROSPACE USA, INC	
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CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 5 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	#	ALTERNATE WEARPLATE KIT	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -013	QTY -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

3		10	AN3C6A	BOLT (REMOVED QTY.2)
4		4	AN3C7A	BOLT (REMOVED QTY.4)
5		38	AN960C10L	WASHER (REMOVED QTY.6)
21A	1		D4095-041	WEARPLATE ASSEMBLY
22A	1		D4095-043	WEARPLATE ASSEMBLY
46	8		D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8		D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4		AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4		AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8		D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12	AN3C6A	BOLT
4		8	AN3C7A	BOLT
5		44	AN960C10L	WASHER
21A		1	D3564-1	WEARPLATE
21B		1	D3564-3	WEARPLATE
22A		1	D3566-1	GASKET
22B		1	D3566-3	GASKET
46	16		D3403-1	BUSHING
49	8		AN4C52A	BOLT
53	16		D3672-11	WASHER

DESIGN	<i>J</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>J</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 6 OF 6
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	ALTERNATE WEARPLATE KIT	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries